

DART AEROSPACE LTD

Work Order:

23463

23315

Description: Fwd Crosstube Extended Height Gear (-013)

Part Number: D205-596-105

Drawing: D205-596-105 Rev: A

Qty: 1

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	U	05-07-12	1
2	DC	Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG001	DU	05-07-12	1
3	LG	Bend D2889 as per Dwg D2889 and Folio FT001 Pick: Qty Part number Description Batch 1 D2889 Fwd Crosstube B19666	DP	05-07-11	1
4	QC6	Inspect dimensions per Dwg D2889	DP	05-07-12	1
5	LG	Deburr and Polish	DP	05-07-14	1
6	FP	Acid etch and alodine Inside and outside of tube as per QSI 005 4.1	DP	05-07-14	1
7	QC5	Inspect work to Step 6			
8	LG	Mark 23.92" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.	DP	05-07-12	1
9	QC6	Inspect dimensions. Conformity check and sign off by engineering.	DP	05-07-12	1
10	LG	Cut as per Dwg D205-596-105	DP	05-07-13	1
11	LG	Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.	DP	05-07-13	1
12	FP	Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1	DP	05-07-13	1
13	QC5	Inspect work to Step 12	DP	05-07-13	1
14	FP	Prime inside and outside with Immron per QSI 005 4.2	DP	05-12-23	1
15	QC14	Inspect Spray paint	DP	05-12-23	1
16	LG	Install Abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-105. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex. Pick: Qty Part number Description Batch 2 D2856-600-851 Abrasion Strip B24328 2 D2893-1 Support B23822 4 MS21920-24 Clamp M18136	DP	06-01-05	1
17	QC5	Inspect work to Step 16	DP	06-01-05	1
18	PK	Identify and pack for shipping as per PPP D205-596-105	REV.C	06-01-05	1
19	AC	Cost / Part:	REV.C	06-01-06	1
20	DC	Close W/O Inspect level 21	REV.C	06-01-06	1

Rev	Date	Change	Revised by	Approved
/A	02.01.10	New Issue	NG/EC	
/B	02.11.11	Re-format; D2889 was D6005-180	KJ	
/C	02.12.11	Modified Steps 4 and 12	KJ/RF	
/D	05.03.21	Added Bending procedure	KJ/JLM	

RECEIVED
2015-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
	10	Cut at 32.7" height 109.125" span tube over bent	<i>AB</i> 10/07/14	cut at 32.7" height 109.125" span as per attached email	<i>AB</i> 05/07/14	<i>AB</i> 05/07/14	<i>AB</i> 10/07/14	<i>AB</i> 15/07/14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/07/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Dan's Mail Box

From: "David Shepherd" <davids@dartaero.com>
To: "Dan's Mail Box" <dans@dartaero.com>
Sent: Thursday, July 14, 2005 1:59 PM
Subject: Re: D205-596-105B23463

The height of 32.7" with a spread of 109.125" is acceptable

David

----- Original Message -----

From: Dan's Mail Box
To: davids@dartaero.com ; Bill Beckett
Sent: Thursday, July 14, 2005 11:46 AM
Subject: Re: D205-596-105B23463

here are the variations in height. nominal height is 32.5" and the span is 109.4"

----- Original Message -----

From: Dan's Mail Box
To: Dan's Mail Box ; Bill Beckett ; davids@dartaero.com
Sent: Thursday, July 14, 2005 12:38 PM
Subject: Re: D205-596-105B23463

here are the final dimensions.
Dan

----- Original Message -----

From: Dan's Mail Box
To: Bill Beckett ; davids@dartaero.com
Sent: Wednesday, July 13, 2005 11:20 AM
Subject: Re: D205-596-105B23463

Any news on this one David?

----- Original Message -----

From: Dan's Mail Box
To: davids@dartaero.com
Sent: Tuesday, July 12, 2005 1:19 PM
Subject: D205-596-105B23463

David,

What should we do with this tube? Half span should be 54.7" with a total span of 109.4".

Dan

